

Date: Thursday, 8/24/2006 11:09:28 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LABEL
Job Number : 28312	
Estimate Number : 10124	
P.O. Number : N/A	Part Number : D2258200
This Issue : 8/24/2006 S.O. No. : N/A	Drawing Number : D2258 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B1
Previous Run : 27689	Material : N/A
Written By : _____	Due Date : 8/31/2006 Qty: 30 Um: Each
Checked & Approved By : _____	
Comment : Est: B 04.04.15 Reformat; Clarify Step 2 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: 1921

C Loc 108125

(30)

Make D2258-200 read 200lb / 91kg as per Dwg D2258

Material: Red letters (1.00" min height) with adhesive back Manufacture from 3M 7mil masking film #8522CP or Avery IPM #2031

Material release note is required

2.0

D2258200P

Weight Placard 200lb

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

WEIGHT PLACARD 200 LB

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure material release note is attached

PU 6/1/29

(30)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

060830 (30)

5.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST433

06/1/30 (30)
LB0608/30 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/31

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/24/2006 11:09:28 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL

Job Number: 28312

Part Number: D2258200

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/08/31 (30)

Job Completion



CY 06/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____




DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2258	SHEET 1 OF 1
DATE	TITLE		SCALE
95.11.29	UTILITY BASKET PLACKARD		1:1
A	94.07.28	NEW ISSUE	
B	95.11.29	ADDED NOTE	
BI	03.08.18	ADDED D2258-160	

RELEASED
99.10.12 KE

1" RED LETTERS ADHESIVE BACK

MAXIMUM DISTRIBUTED LOAD
XXX lb/ XXX kg

EXAMPLE

PART #	LOAD
D2258-132	132 lb/60 kg
D2258-200	200 lb/91 kg
D2258-220	220 lb/100 kg
 D2258-160	160 lb/73 kg

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28312



PRODUCT DATA BULLETIN

Product Data Bulletin: A5-O

Avery Graphics™ A5 Opaque
5-year **INTERMEDIATE** calendered vinyl film
Dated: 10/3/02

Description:

Avery Graphics™ A5 Opaque intermediate films are flexible, high-gloss calendered vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendered vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

Physical Properties:

The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)**
- Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 68°-77° F (20° - 25° C) and 50±5% R. H.
- Typical Adhesion Values: **180° Peels**

Substrate	24 hrs	1 week
Stainless Steel	4.4 lbs/in	5.1 lbs/in
Glass	4.7 lbs/in	5.3 lbs/in

NOTE: Tested per ASTM D 1000. Always pre-test your specific substrate prior to actual application.

- Reflectivity: NA
- Typical Gloss*: 70 at 60°

- Tensile at Yield: 9.0 lbs/in to 15.0 lbs/in width
- Elongation: 100% minimum
- Dimensional Stability: Less than 0.03 in. (0.762mm). Shrinkage is determined by measuring shrinkage of unprinted film applied to to 36 in.² (91 cm²) aluminum test panel after 72 hrs. aging at 73° F (23° C) 50±5% R.H. followed by 48 hrs. at 150° F (65° C).

Typical Converting Methods:

CUTTING

Computer Sign Cutting: yes

Angle of Blade: 30° or 45°

Minimum letter Height: 0.5 inch

PRINTING

Thermal Transfer Printing: yes

Ink Jet Printing: no

E-Stat printing: no

Screen Printing: no

Exceptions:

Durability Exceptions: Colors with reduced durabilities are as follows: A5077-O Silver and A5247-O Gold are 3-year durable and A5003-O Clear is 4-year durable.

Gloss Exceptions: A5077-O Silver, A5247-O Gold and A5508-O Vibrant Blue have a typical gloss of 50 at 60°.

Pigmented Adhesive Exceptions: none

** Some color fade may occur in severe environmental areas such as, Florida, Arizona, Nevada, New Mexico, Utah, Southwest Texas and Southern California. Durability statement does not apply outside of the contiguous 48 states as testing has not been done in those regions.

WARRANTY: All statements, technical information and recommendations about Avery Dennison products are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All Avery Dennison products are sold with the understanding that Purchaser has independently determined the suitability of such products for its purposes. Avery Dennison products are warranted to be free from defects in material and workmanship for either one year (or the period stated on the specific product information literature in effect at time of delivery, if longer) from date of shipment if said product is properly stored and applied. It is expressly agreed and understood that Avery Dennison's sole obligation and Purchaser's exclusive remedy under this warranty, under any other warranty, express or implied, or otherwise, shall be limited to repair or replacement of defective product without charge at Avery Dennison's plant or at the location of product (at Avery Dennison's election), or in the event replacement or repairs is not commercially practical, to Avery Dennison's issuing Purchaser a credit reasonable in light of the defect in the product.

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